

Work Order ID 62405

September 29, 2010 12:15:07 PM

PRELIMINARY ISSUE

Page 1

Item ID: D212-805-011

Accept

Setup Start

Revision ID: PRELIM

Item Name: Pod Modification Installation

Stop

Start Date: 9/29/10 Start Qty: 1.00

Cust Item ID:

Required Date: 9/29/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D212-805

PA1

100

0.00

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D212-601-042
CHG001

110

0.00

Small Fab

Memo

0.00

Small Fab

1- Locate DT9667 jig on pod lid as per dwg, open holes as per dwg (1.00" holes
is open with a hole saw)
2- Seal all edges with cyanoacrylate glue

120

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

ST 10-09-27

Su6229

10-09-29

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Item ID: D212-805-011

Accept

Setup Start

Revision ID: PRELIM

Stop

Item Name: Pod Modification Installation

Start Date: 9/29/10 Start Qty: 1.00

Cust Item ID:

Required Date: 9/29/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

0.00

Small Fab

Memo

0.00

Small Fab

Install D4175-1 pod Gps doubler (bond with sikaflex)
Use DT9667 jig to hold doubler in place while sikaflex cures
A/R Sikaflex Batch: 115114
exp date: 11-01-01

85 10-09-27

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

810/09/bs
10-09-27

150

0.00

Small Fab

Memo

0.00

Small Fab

1- Locate DT9668 jig on aft, inside half of rear pannel on pod as per dwg
2- Drill out holes to .191" (6 places) use bolts .1875" to hold jig in place.
3- Use router to remove inner square
4- Seal all edges with cyanoacrylate glue

85 10-09-27

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Item ID: D212-805-011
Revision ID: PRELIM
Item Name: Pod Modification Installation

Accept

Setup Start

Stop

Start Date: 9/29/10 Start Qty: 1.00
Required Date: 9/29/10 Req'd Qty: 1.00

Cust Item ID:
Customer:

Reference:

Approvals: Process Plan:
QC:

Date:
Date:

Tooling:
SPC (Y/N):

Date:
Date:

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Sikaflex
10-09-29

170

0.00

Small Fab

Memo

0.00

Small Fab

Bond and bolt on D4174-1, D4174-3 connector plate and doubler using sikaflex and appropriate hardware.

A/R Sykaflex Batch: 115114
exp date: 11-01-01

ET 10-09-27

180

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Sikaflex
10-09-29

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Item ID: D212-805-011

Accept

Setup Start

Revision ID: PRELIM

Item Name: Pod Modification Installation

Stop

Start Date: 9/29/10 Start Qty: 1.00

Cust Item ID:

Required Date: 9/29/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

0.00

Small Fab

Memo

0.00

Small Fab

1- Locate DT9669 jig on outside of base on pod as per dwg. ***Orientation and groove of jig as per dwg***
2- Open holes and seal holes with cyanoacrylate glue as per dwg and seal exposed foam core with Hysol 956 and milled fiber
A/R Hysol Batch: 113477
exp. date: 10-12-17
A/R Milled fiber Batch: 160859
3- Allow resin to cure for min. 12HRS and remove excess.

25 10-09-27

200

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Subs/b9
10-09-27

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Item ID: D212-805-011

Accept

Setup Start

Revision ID: PRELIM

Stop

Item Name: Pod Modification Installation

Start Date: 9/29/10 Start Qty: 1.00

Cust Item ID:

Required Date: 9/29/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

0.00

Small Fab

Memo

0.00

Small Fab

Install Radalt mounting plate assy as per dwg (Detail C) and bond doubler and shim with Sykaflex
A/R Sykaflex Batch: 115114
exp date: 11-01-01

BT 10-09-27

220

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/10/09/09
11/01/01

230

0.00

Small Fab

Memo

0.00

Small Fab

1- Using D4177-1 Radalt guard doubler to locate holes and spacing
Drill from outside of pod to ensure location doesn't affect ribs on base
2- Install parts seal and bond with sikaflex
A/R Sykaflex Batch: 115114
exp date: 11-01-01

BT 10-09-27

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Item ID: D212-805-011

Accept

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Item Name: Pod Modification Installation

Stop

Start Date: 9/29/10 Start Qty: 1.00

Cust Item ID:

Required Date: 9/29/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Sulorby
10.09.29

250

0.00

Small Fab

Memo

0.00

Small Fab

1- Locate D4172-041 mounting frame in base of pod as per dwg and use mounting frame to locate holes for inserts.

2- Open holes to size.

3- Pot insert as per dwg

A/R Hysol Batch: 115680exp. date : 11-09-06

4- Allow resin to cure then install mounting frame.

CT 10-09-27

260

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Sulorby
10.09.29

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Item ID: D212-805-011

Accept

Setup Start

Revision ID: PRELIM

Item Name: Pod Modification Installation

Stop

Start Date: 9/29/10 Start Qty: 1.00

Required Date: 9/29/10 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

270

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D212-601-142

Location: _____

PPP rev: _____

20 10/5/29 ①

280

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

*MF
10-9-29*

POSITIVE RECALL

EFFECTIVE 10/9/29 AUTH U

RELEASED 10/9/29 DATE 10/09/29

Picklist Print

September 29, 2010 12:14:59 PM

Work Order ID: 62405

Parent Item: D212-805-011

Parent Item Name: Pod Modification Installation

Start Date: 9/29/10

Required Date: 9/29/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.29 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4173-9		Manufactured	No				Each	0.0000	1	1	RT	10-09-27	
Pod Radalt Seal													
D4175-041		Manufactured	No			130	Each	1.0000	1	1	RT	10-09-27	
Pod GPS Doubler Assembly													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					CA	1							
					61883	1				XL			
D4174-1		Manufactured	No			170	Each	1.0000	1	1			
Connector Plate													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					CA	1							
					61881	1				XL			
D4174-3		Manufactured	No			170	Each	1.0000	1	1			
Connector Plate Doubler													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					CA	1							
					61882	1				XL			

Picklist Print

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Work Order ID: 62405

Parent Item: D212-805-011

Parent Item Name: Pod Modification Installation

Start Date: 9/29/10

Required Date: 9/29/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L3	Purchased	No	170	Each	1,801.000	6	6
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Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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ST300	1801	
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114523	49	
--------	----	--

<u>114784</u>	1752	
---------------	------	--

NAS1149D0363J	Purchased	No	170	Each	2,838.000	12	12
---------------	-----------	----	-----	------	-----------	----	----

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST298	2838	
-------	------	--

114292	114	
--------	-----	--

115107	27	
--------	----	--

<u>115622</u>	2688	
---------------	------	--

9221	9	
------	---	--

AN3-5A	Purchased	No	170	Each	1,463.000	6	6
--------	-----------	----	-----	------	-----------	---	---

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST350	1463	
-------	------	--

<u>105057</u>	463	
---------------	-----	--

115016	500	
--------	-----	--

115371	500	
--------	-----	--

D4173-3	Manufactured	No	210	Each	1.0000	1	1
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Pod Radalt Doubler

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

CA	1	
----	---	--

<u>61880</u>	1	
--------------	---	--

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Work Order ID: 62405

Parent Item: D212-805-011

Parent Item Name: Pod Modification Installation

Start Date: 9/29/10

Required Date: 9/29/10

Start Qty: 1.00

Required Qty: 1.00

D4173-7	Manufactured	No	210	Each	1.0000	1	1
---------	--------------	----	-----	------	--------	---	---

Radalt Shim

RT 10-09-27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

CA	1	
<u>61969</u>	1	<u>71</u>
D4173-041	Manufactured	No
210	Each	1.0000
1		1

Pod Radalt Mounting Plate Assembly

RT 10-09-27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

CA	1	
<u>61963</u>	1	<u>71</u>
AN3-12A	Purchased	No
210	Each	126.0000
12		12

Bolt

RT 10-09-27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST351	126	
<u>114494</u>	30	<u>712</u>
<u>114536</u>	96	

MS21042L3	Purchased	No	210	Each	1,801.000	6	12
-----------	-----------	----	-----	------	-----------	---	----

Nut

RT 10-09-27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST300	1801	
<u>114523</u>	49	
<u>114784</u>	1752	<u>712</u>

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Work Order ID: 62405

Parent Item: D212-805-011

Parent Item Name: Pod Modification Installation

Start Date: 9/29/10

Required Date: 9/29/10

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P	Purchased	No	210	Each	599.0000	24	24
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WASHER

RT 10-09-27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST275	599	
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<u>18057</u>	599	
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AN3-6A	Purchased	No	230	Each	230.0000	4	4
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x 24

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST351	230	
-------	-----	--

<u>113359</u>	30	
---------------	----	--

114941	200	
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NAS1149F0332P	Purchased	No	230	Each	599.0000	24	8
---------------	-----------	----	-----	------	----------	----	---

x 4

WASHER

RT 10-07-27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST275	599	
-------	-----	--

<u>18057</u>	599	
--------------	-----	--

D4177-1	Manufactured	No	230	Each	1.0000	2	2
---------	--------------	----	-----	------	--------	---	---

+ 8

Radalt Guard Doubler

RT 10-09-27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

CA	1	
----	---	--

<u>61884</u>	1	
--------------	---	--

x 2

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Work Order ID: 62405

Parent Item: D212-805-011

Parent Item Name: Pod Modification Installation

Start Date: 9/29/10

Required Date: 9/29/10

Start Qty: 1.00

Required Qty: 1.00

MS21042L3	Purchased	No	230	Each	1.801.000	6	4
-----------	-----------	----	-----	------	-----------	---	---

Nut

ET 10-09-27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST300	1801	
114523	49	
<u>114784</u>	1752	<u>x4</u>

D3926-3	Manufactured	No	230	Each	4.0000	2	2
---------	--------------	----	-----	------	--------	---	---

Wedge

ET 10-09-27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST098	4	
58851	4	<u>x2</u>

D4172-041	Manufactured	No	250	Each	1.0000	1	1
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~~31934~~

ET 10-09-27

Pod Mounting Frame Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

CA	1	
<u>61934</u>	1	<u>x1</u>

80-005-3-8	Purchased	No	250	Each	44.0000	8	8
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Insert

ET 10-09-27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST379	24	
115271	4	
115669	20	
ST380	20	
<u>115708</u>	20	<u>x8</u>

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Work Order ID: 62405

Parent Item: D212-805-011

Parent Item Name: Pod Modification Installation

Start Date: 9/29/10

Required Date: 9/29/10

Start Qty: 1.00

Required Qty: 1.00

AN4-4A	Purchased	No	250	Each	194.0000	8	8
--------	-----------	----	-----	------	----------	---	---

Bolt

RT 10-09-27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST356	191	
114615	191	
ST361	3	
108138	2	
111295	1	

X4

RT

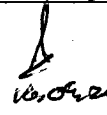
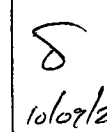
NAS1149F0432P	Purchased	No	250	Each	362.0000	8	8
---------------	-----------	----	-----	------	----------	---	---

Washer

RT 10-09-27

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST275	362	
112940	92	
114405	1	
114576	10	
114718	59	
115698	200	

X8

W/O: 62405		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-09-27	250	AN4-4A bolts too short install 42 AN4-7A bolts instead AN4-7A x4 B <u>113226</u>	ET	10-09-27	x4	 10/09/27	 10/07/29

Part No: D212-805-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

① Route D4175-1 jig on pod lid as per DWG ~~DSK-128~~
~~and~~ open holes as per DWG. ~~DSK-128~~ D212-601-142 Rev A
4 outer holes \varnothing 0.140" 4 places
open center hole to \varnothing 1.000 using hole saw

② seal all edges w/ cyanoacrylate glue

③ install D4175-1 pod GPS doubler (Bond w/ sikaFlex)

note: use D4175-1 jig to hold doubles in
place while sikaFlex cures

- D4175-041 x1 B 61883
pod GPS doubler

sikaFlex B 115114

21 10-07-27

Route D4174-3 jig on ast, inside half of rear
panel on pod as per DWG ~~DSK-128~~ D212-601-142 Rev A

Drill out holes to \varnothing 0.191" 6 places
use bolts .1875" to hold jig in place

use router to remove inner square

seal all edges w/ cyanoacrylate glue

Bond + Bolt on D4174-1 and D4174-3 connector
plate + doubler using sikaFlex + appropriate hardware

- D4174-1 connector plate x1 B 61881

- D4174-3 connector plate doubler x1 B 61882

~~AN3-51 Bolt~~ ~~x6 B 114784~~

- MS 21042L3 nut x6 B 114784

~~AN3-51 Bolt~~ ~~x12 B 115622~~

- NAS1149-03655 washer ~~x6 B 105057~~

- AN3-51 Bolt x6 B 105057

21 100727

locate DA 4173-3 jig on outside of base
on pod as per DWG ~~note~~. Note orientation
and groove of jig as per DWG. ~~0212-601-143 Rev A~~

open outer holes to ϕ 0.201" 12 places

open center hole to 2.250 using hole saw

seal 0.201" holes w/ cyanoacrylate glue
seal 2.250 hole + exposed foam core w/ Hysol 956
+ milled fiber

Hysol 956 B 113477
expiry date 10-12-17

milled fiber B 100859

allow resin to cure for min 12 hrs + remove
excess

install radalt mounting plate Assy as per
DWG ~~Detail A~~ Detail H

Bonding Doubler, shim ~~and use of Sikaflex~~ Sikaflex

Sikaflex B 115114

- 4173-3 Doubler x 1 B 61880

- 4173-7 shim x 1 B 61969

- 4173-04 mounting plate x 1 B 61963

- AN3-12A bolt x 12 B 114494

- MS21042L3 nut x 12 B 114784

- NAS 1149F0332P washer x 24 B 18057

- 74173-1 seal x 1 B 115500

~~100127~~
100127

using 4177-1 Radalt quad doubler to locate
holes + spacing

note drill from outside of pod to ensure

location doesn't affect ribs on base

install parts sealing + bonding w/ sikaflex

- AN3-6A Bolt x 4 B 113359

- NAS 1149F0332P washer x 8 B 18057

- 4177-1 Radalt quad doubler x 2 B 61884

- MS21042L3 nut x 4 B 114784

- D3126-3 wedge x 2 B 58851

~~100127~~
100127

Locate D4172-041 mounting frame in
base of pod as per DWG ~~DSE 128~~ D212-601-142 Rev A
use mounting frame to locate holes for
inserts

open holes to

pot inserts c/o per DSE 006

~~poor~~

9309,3

Hysol ~~9309~~ B 115680

expiry date 11 09 06

allow resin to cure then install
mounting frame

- D4172-041 mounting frame x1 B 61934
- 80-005-3-8 potted insert x8 B 115708
- AN4-4A Bolt x4 B 114615
- NAS1149F0432P washer x8 B 114716
- AN4-7A x4 B 113226

DS 100927